



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3208-1

Job Sheet 179693



Part No: D3208-1

Job Qty: 6 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP: B 04.05.25 Material changed for Step 4 KJ/JLM IPP REV B:PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:C 12.04.20 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SC 186704
100	Waterjet	6 pcs		7/18/18	0.00	0.39	Waterjet1		SC 186704
115	QC	6 pcs		7/18/18	0.00	0.00	QC8		38
120	Brake NC	6 pcs		7/18/18	0.03	0.31	Brake NC 2		38
130	QC	6 pcs		7/18/18	0.00	0.00	QC5		38
140	HandFinish	6 pcs		7/18/18	0.00	0.19	HandFinish1		D.R. 18/08/18
150	QC	6 pcs		7/18/18	0.00	0.00	QC7-2		AUG 16 2018 38
160	Packaging	6 pcs		7/18/18	0.00	0.00	Packaging3-1	5025	AUG 20 2018 9-89
170	QC21-SA	6 Ea		7/18/18	0.00	0.00	QC21		AUG 20 2018 9-89

Part Op
Descriptions: 100 - 1-Cut as per Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.9870 sf (.1645 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.098inches + 0.005 - 0.001	0.103 0.097	0,098	
2	Doubler	0.130inches ± 0.030	0.160 0.100	0,130	
3	Doubler	4.060inches ± 0.030	4.090 4.030	4,056	
4	Doubler	5.600inches ± 0.030	5.630 5.570	5,60	
5	Doubler	0.040inches ± 0.010	0.050 0.030	0,040	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
Suspect ☐								

Date : _____ Step #: _____

Description Work Order Deviation

(QSI042) Approval
 Completed By _____
 and / Supervisor
 oval Verification
 QA Coordinator
 Approval

DART
 AEROSPACE
 Part: D3208-1
 Job No: 179693
 Serial No/Batch: S089820
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 07/07/18

Container No: S089820
 DART Aerospace Ltd.
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 Cambridge, ON K4A 1K7
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 Web: dartaerospace.com

Root Cause			
Environment ☐	No Re-verification ☐	Pressure ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	